

May-01-12 10:45:53 AM

Item ID: D3940-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Floor Protector (407)

Stop *NS2*

Start Date: 01/05/2012 **Start Qty:** 5.00

5

Cust Item ID:

Required Date: 15/05/2012 **Req'd Qty:** 5.00

5

Customer:

Reference:

Approvals: Process Plan: MLJ Date: 12/05/02 Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

| | |
|-----------------|---------------------|
| Draw Nbr | Revision Nbr |
|-----------------|---------------------|

D3940-1 REV A

100

0.00

100

HandThermo

Memo

0.00

Hand Finishing Thermoforming

1-Cut Sheet to required Blank size

105

0.00

105

Dry Material

HandThermo

Memo

0.00

Hand Finishing Thermoforming

Dry Sheet as per QSI022 POLYCARBONATE

Temp: 240

Time IN: 4:30

Time OUT: 1:00

B12/05/10

3B 12/05/10

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

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NOTE: Date & initial all entries

84028

May-01-12 10:45:53 AM

N900040100

Setup Start ***NS1***

Stop ***NS2***

5

5

Reference:

Run Start *NR1*

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

0.00

140

0.00

HandThermo

Memo

Hand Finishing Thermoforming

1-Trim to finished dimensions as per Dwg

QC2- Inspect parts off machine FAI/FAIB

0.00

150

0.00

QC

Memo

Quality Control

Complete FAI document

QC5- Inspect part completeness to step on W/O

0.00

160

0.00

QC

Memo

Quality Control

| W/O: | | WORK ORDER CHANGES | | | | | |
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NOTE: Date & initial all entries

May-01-12 10:45:53 AM

Item ID: D3940-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Floor Protector (407)

Stop *NS2*

Start Date: 01/05/2012 **Start Qty:** 5.00

5

Cust Item ID:

Required Date: 15/05/2012 Req'd Qty: 5.00

5

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/
Work Center ID

Operation Description

Set Up/ Run Hours

Tool ID

Tool #

Plan
Code

**Accept
Qty**

Reject
Qty

Reject Number

**Insp.
Stamp**

170

Identify as per dwg & Stock Location: _____

0.00

AP 84023

170

Packaging

Memo

0.00

Packaging

180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

0.00

Quality Control

12/5/16

mf
12-05-17

| W/O: | | WORK ORDER CHANGES | | | | | | |
|------|------|--------------------|------------------|----|------|-----|-------------------------------------|--------------------------|
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NOTE: Date & initial all entries

Picklist Print

May-01-12 10:45:56 AM

Page 1

Work Order ID: 84028

84028

Parent Item: D3940-1

D3940-1

Parent Item Name: Floor Protector (407)

Start Date: 01/05/2012

Required Date: 15/05/2012

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP Rev. A New Issue 09/02/06 DL
Add Step 105 Dry Material 10/04/21 DL

IPP Rev B

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| MLEXS.118-90318-08 | | Purchased | No | | | 100 | sf | 1,290.266 | 9.03 | 45.15 | | | |

MI FXS 118-90318-08

Lexan Sheet

**

12/05/15

Location

Loc Qty

Loc Code

therm

113127

1290.266941

1290.26694

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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NOTE: Date & initial all entries

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|--------------------------------------------|--|---------------------|---------|
| DART AEROSPACE LTD | | Work Order: | 84025 |
| Description: Floor Protector | | Part Number: | D3940-1 |
| Inspection Dwg: D3940 Rev: A | | Page 1 of 1 | |

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype



THERMOFORMING SECTION



| Description | Accept | Reject | Method of Inspection | Comments |
|-----------------------------------------------------------------|--------|--------|----------------------|----------|
| Inside Radii less than _____" | ✓ | | | |
| Shape Definition | ✓ | | | |
| Texture Retention | ✓ | | | |
| Material imperfections such as bumps, cracks, voids, scratching | ✓ | | | |
| | | | | |
| | | | | |
| | | | | |
| | | | | |

| | |
|-------------------------------------------------------------------------------------------------------|--------------|
| Measured by:  | Date: |
|-------------------------------------------------------------------------------------------------------|--------------|

TRIMMING SECTION

| Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|-------------------|-----------|------------------|--------|--------|----------------------|----------|
| 45.8 | REF | 45.8 | ✓ | | | |
| 20.8 | REF | 20.9 | ✓ | | | |
| 0.50 | Min | .55 | ✓ | | | |
| 0.62 | Min | .70 | ✓ | | | |
| 0.38 | Min | .40 | ✓ | | | |
| 0.080 | Min | .081 | ✓ | | | |
| 0.050 | Min | .100 | ✓ | | | |
| | | | | | | |
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| | |
|---------------------------------------------------------------------------------------------------------|-----------------------|
| Measured by:  | Date: 12/05/14 |
| Audited by:  | Date: 12/05/15 |
| Prototype Approval: N/A | Date: N/A |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|-----------|------------------------------------------------------------------------------------------|---------------------------------------------------------------------------------------|
| A | 09.09.17 | New Issue | KJ  |  |

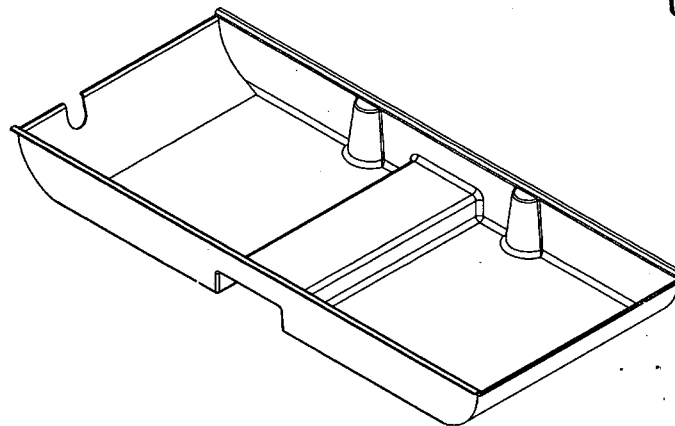
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NOTE: Date & initial all entries



SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 841028

12-05-2

D3940-1 FLOOR PROTECTOR (407)

RELEASED
9/18/08

NOTES:

- 1) MATERIAL: LEXAN 90318 (PROTECT-A-GLAZE), 0.118 THICK, 112-CLEAR (MLEXS.118-90318-08)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3940-1" USING VIBRATING STYLUS
- 7) WEIGHT: 4.5 lbs
- 8) TOOLING: THERMOFORM PER MOLD DT9502 PER DART QSI 022. TRIM PER MOLD
- 9) MINIMUM THICKNESS: 0.050" EXCEPT AS SHOWN

| A | | NEWISSUE | PH | 09.04.01 |
|------------|--------------------|----------------------------------------------------------|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|----------|
| REV. | DESCRIPTION | | BY | DATE |
| DESIGN | <i>PH</i> | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | | |
| DRAWN | <i>PH</i> | | | |
| CHECKED | | DRAWING NO. | REV. A | |
| MFG. APPR. | <i>[Signature]</i> | D3940 | SHEET 1 OF 2 | |
| APPROVED | <i>[Signature]</i> | TITLE | SCALE | |
| DE APPR. | <i>[Signature]</i> | FLOOR PROTECTOR (407) | NTS | |
| DATE | 09.04.01 | | <small>COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR DISSEMINATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small> | |

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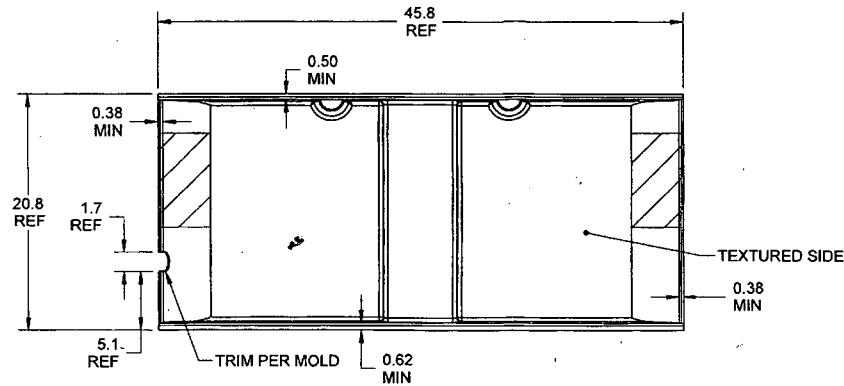
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NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

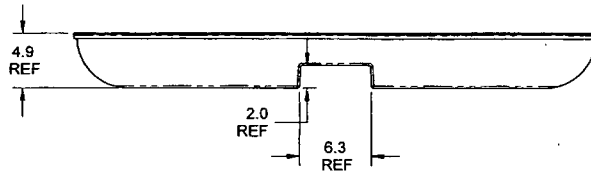
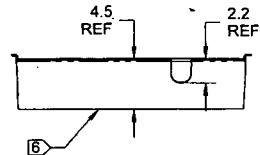
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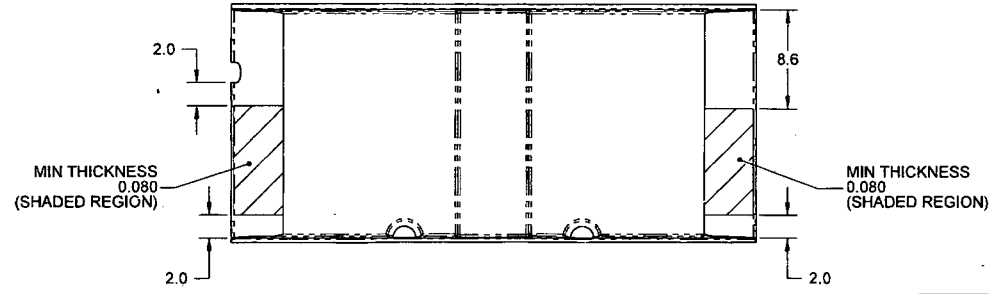
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D3340-1 FLOOR PROTECTOR (407)

84028

RELEASED
01/06/08

| | | | |
|------------|----------|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------------|
| DESIGN | PH | DART AEROSPACE LTD | |
| DRAWN | PH | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | | DRAWING NO. | REV. A |
| MFG. APPR. | | D3940 | SHEET 2 OF 2 |
| APPROVED | | TITLE | SCALE |
| DE APPR. | | FLOOR PROTECTOR (407) | NTS |
| DATE | 09.04.01 | <small>COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small> | |

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